Work Orde										<u> </u>		Page 1
Friday, September 11.	er 03, 2010 9:5 D3531-3	52:43 AM				4 3	II ((8)(88)() (1 18611111 8	
Revision ID:	D3331-3		A	Accept				S	etup S	Start		
	Bracket Front Pla	ate								Stop		
Start Date:	9/3/2010	Start Qty: 5.00			Cust Item II	D:						
Required Date:	9/13/2010 I	Req'd Qty: 5.00			Customer:							
Reference:												
Approvals:	Process Plan:	N	Date: 10-9-03	Tooling:	Da	ite:	THE STATE OF THE S	R	un (Start		
	QC:		_ Date:	SPC (Y/N):	Da	te:				Stop		
Sequence ID/ Work Center II		Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Rejec Qty		Reject Number	Insp. Stamp
Draw Nbr	Revisi	on Nbr							,	,		
D3531	Rev A											
	F	LOW WATER JET		0.00				IK	10-	7- 14	5	
Waterjet FLOW CNC Waterje		Memo 1-Cut as pe Dwg Rev:_ Prog Rev:_ 2-Deburr if	necessary	0.00						•	(
110 ((410)	Ç	QC2- Inspect parts off n	nachine FAI/FAIB	0.00								
QC Quality Control		Memo		0.00				<u>B</u>	10 <u>~9</u> .	-15		-

120 QC

Quality Control

Memo

QC8- Inspect parts - second check

Filsolos 2000



W/O: WORK ORDER CHANGES	
DATE STEP PROCEDURE CHANGE By Date Qty 6	Approval Chief Eng / Prod Mar
	Prod Mgr QC Inspector
Part No: PAR #: Fault Category: NCR: Yes No DQA:	Date:
Resolution: Disposition: QA: N/C Closed:	_ Date:
NCR: WORK ORDER NON-CONFORMANCE (NCR)	
DATE STED Description of NC Corrective Action Section B Verification	Approval Approval
DATE STEP Description of NC Section A Initial Action Description Sign & Date Verification Section C	Chief Eng QC Inspector

Work Order ID 61781

Friday, September 03, 2010 9:52:43 AM



Page 2

Item ID:

D3531-3

Accept



Setup Start



Revision ID:

Item Name:

Bracket Front Plate

Start Date:

Required Date: 9/13/2010

9/3/2010

Start Qty: 5.00

Req'd Qty: 5.00



Cust Item ID: Customer:

Reference:

Approvals:

Process Plan:

QC:

Date: Date:_____

Tooling: SPC (Y/N):

Date:

Date:

Start

Run



Stop

Stop

Sequence ID/ **Work Center ID**

130

140

Small Fab

Operation Description

Small Fab

Set Up/ **Run Hours**

Tool ID

Code

Tool # Plan

Accept Qty

Reject **Qty**

Reject Number

Insp. Stamp

Small Fab

Brake NC

Brake NC

NC BRAKE

Memo

Bend as per Dwg D3530

0.00

0.00

SB voloalor

150

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

Scolorly

	WORK ORDER CH	IANGES				
STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
	STEP		STEP PROCEDURE CHANGE By		*	STEP PROCEDURE CHANGE By Date Qty Chief Eng /

Part No: <u>D353 - 3</u>	PAR #:	Fault Category: Small Fab	NCR: Yes No DQA:	/ Date: <u>/0・0 5・2 8</u>
Resolution:	Accepted	Disposition: 12e ps 13.	QA: N/C Closed:	Date:

NCR:	1781	W	ORK OR	DER NON-CONFORMANCE	(NCR)			
		Description of NC		Corrective Action Section B		Verification	Approval	Approval
DATE STEP		Section A	Initial Action Description Chief Eng Chief Eng			Section C	Approval Chief Eng	QC Inspector
(४/०१/२।	140	part suppose to be 2.32 tigo Is 2.335 R.c. Begining setup.	Bon	-1 bracked has a to.030 toler	Sologla	10/04/11	Boon	10-09-21
				ance to accomershale		(010(1)(
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Work Order ID 61781

Friday, September 03, 2010 9:52:43 AM



Page 3

Item ID:

D3531-3

Accept

Ø

Setup Start



Revision ID:

Item Name:

Bracket Front Plate

Start Date:

9/3/2010

Start Qty: 5.00

Required Date: 9/13/2010

Req'd Qty: 5.00



Cust Item ID: Customer:

Reference:

Approvals:

Process Plan: _____ Date: ____

Operation

Description

Chemical Conversion Coat per QSI005 4.1

Tooling:

Date:

Run

Start

Stop



QC:

Date:_____

SPC (Y/N):

Date: Tool ID

Tool # Plan

Code

Stop

Sequence ID/ **Work Center ID**

160

HandFinish Hand Finishing

Memo

Set Up/ Run Hours

0.00

0.00

Accept Qty

Reject Qty

Reject Insp. Number Stamp

170

OC

Quality Control

QC3- Inspect Part Finish

0.00

180

Packaging

Packaging

Identify as per dwg & Stock Location:

Memo

0.00

0.00

(10/5/2 (6)

Memo

W/O:	-		W	ORK ORDER CHANG	ES	-				
DATE	STEP	PRO	PROCEDURE CHANGE						Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	•	PAR #:	Fault Cat	egory:		Yes N	lo DQ	A:	Date: _	
		esolution:								
NCR:			WORK ORE	DER NON-CONFORMA	NCE (I	VCR)				
DATE	STEP	Description of NC		Corrective Action Section			Verific	cation	Approval	Approval
DATE	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng		ign & Date	Secti		Chief Eng	QC Inspector
		•								
						***************************************		<u>.</u>		

Work Order ID 61781

Friday, September 03, 2010 9:52:43 AM



Page 4

Item ID:

D3531-3

Accept



Setup Start

Stop



Revision ID:

Item Name:

Bracket Front Plate

Start Date:

9/3/2010

Start Qty: 5.00

Required Date: 9/13/2010 Req'd Qty: 5.00



Cust Item ID:

Customer:

Reference:

Approvals:

QC:

Process Plan:

Operation

Tooling: Date:

SPC (Y/N):

Date: Date: Run

Qty

Start

Stop



Sequence ID/

Work Center ID

190

Description

Memo

QC21- Final Inspection - Work Order Release

Set Up/ **Run Hours**

0.00

Tool ID

Tool # Plan Code

Accept Qty

Reject Reject Number

Insp. Stamp

Date:

0.00

Quality Control

ME 10-9-24

		WO	RK ORDER CHANG	GES					
STEP	PR	OCEDURE CHAI	NGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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					į				
•	PAR #:	Fault Cateo	gory:	NCI	R: Yes	No DQ	A:	Date: _	
Res	olution:	Disposition	n:	QA	N/C Cld	sed:		Date: _	·
		WORK ORDE	ER NON-CONFORM	ANCE	(NCR)			
CTED	Description of NC	\				Verific	cation	Approval	Approval
SIEP	Section A	Initial Chief Eng	Action Description Chief Eng					Chief Eng	QC Inspector
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		:PAR #: Resolution: STED Description of NC	STEP PROCEDURE CHAR PROCEDURE CHAR PAR #: Fault Cate Resolution: Disposition WORK ORDE STEP Description of NC Section A Initial	STEP PROCEDURE CHANGE PROCEDURE CHANGE Fault Category: PAR #: Fault Category: Disposition: WORK ORDER NON-CONFORM STEP Description of NC Section A Corrective Action Section A Corrective Action Description	:PAR #: Fault Category: NCF Resolution: Disposition: QA: WORK ORDER NON-CONFORMANCE STEP Description of NC Section A	STEP PROCEDURE CHANGE By PAR #: Fault Category: NCR: Yes Resolution: Disposition: QA: N/C Clo WORK ORDER NON-CONFORMANCE (NCR) STEP Description of NC Section A STEP Description of NC Section A STEP Section A Initial Action Description Sign &	STEP PROCEDURE CHANGE By Date	STEP PROCEDURE CHANGE By Date Qty	STEP PROCEDURE CHANGE By Date Qty Chief Eng / Prod Mgr : PAR #: Fault Category: NCR: Yes No DQA: Date: Partial Category: NCR: Yes No DQA: Date: Partial Category: NCR: Yes No DQA: Date: PAR #: PAR #: Fault Category: NCR: Yes No DQA: Date: PAR #:

Picklist Print

Friday, September 03, 2010 9:52:48 AM

Work Order ID: 61781

D3531-3 Parent Item:

Parent Item Name: Bracket Front Plate

Start Date: 9/3/2010

Required Date: 9/13/2010

Page 1

Start Qty: 5.00

Required Qty: 5.00

Comments:

IPP Rev:A New Issue 07-09-24 EC verified by DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.040		Purchased	No			100	sf	86.7300	0.1313	0.691053		8	
6061-T6 .040 Sheet	30))012 10 (10))1 00)11 0)011 0111 11	111							1 100hi 100h 		(B10-	9-15	
				Location	<u>1</u>	Loc	<u>Oty</u>	Loc Code			/	(r)	

MAT21

86.73 113004

86.73

113004

Dant Ac	, ospaci	Liu							
W/O:			WO	RK ORDER CHANGE	ES				
DATE	STEP	PRO	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
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Part No):	PAR #:	Fault Categ	jory:	NCR: Yes	No DQ	A:	_ Date: _	<u> </u>
	R	Resolution:	Disposition	1:	QA: N/C CI	osed:		Date: _	
NCR:		\	WORK ORDE	R NON-CONFORMA	NCE (NCF	R)			
		Description of NC	Corrective Action		Section B		cation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign 8 Date		ion C	Chief Eng	QC Inspector
		·							

DART AEROSPACE LTD	Work Order:	41781
Description: Bracket Front Plate	Part Number:	D3531-3
Inspection Dwg: D3531 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Х	First Article		Prototype
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Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.129	+0.005/-0.001	,130	×		V HBOD	
3.72	+/-0.030	3,725	h /		V	
0.37	+/-0.030	,373	*		V	
2.840	+/-0.010	7.834	X		V	
0.88	+/-0.030	\88\	×		٧	
3.50	+/-0.030	3,499	×		٧	
4.67	+/-0.030	4.666	(ex		V	
				·· .		2.444

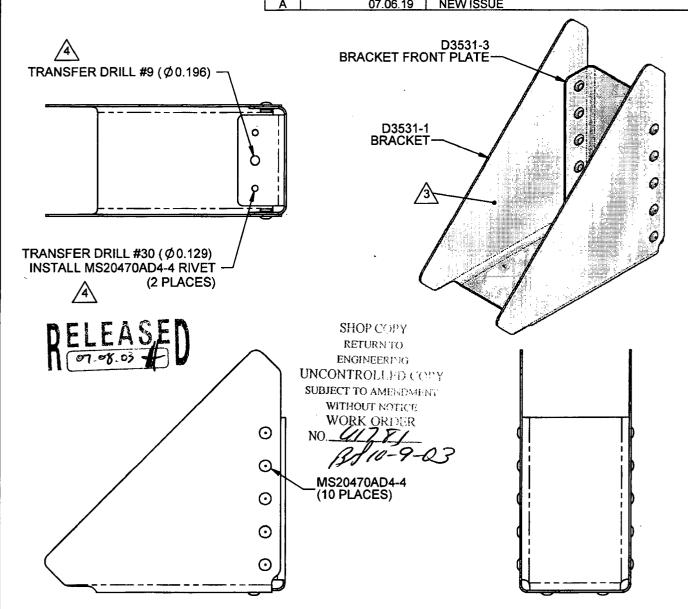
Measured by:	Audited by:	Prototype Approval:	N/A
Date: 10, 9-15	Date: (0(6) 17	Date:	N/A

Rev	Date	Change	Revised by	Approved
Α	07.10.15	New Issue	KJ/EC/DD	

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W/O:		WORK ORDER CHANGES						Approval	A
DATE	STEP	PRO	OCEDURE CHA	ANGE	Ву	Date	Qty	Chief Eng / Prod Mgr	Approval QC Inspector
						İ			
Part No: PAR #:			Fault Cate	ult Category: NCR: Yes No DQA:					
	R	esolution:	Disposition	Disposition: QA: N/C Closed: Date:					
NCR:	· · · · · · · · · · · · · · · · · · ·		WORK ORD	ER NON-CONFORMA	ANCE (NC	R)			
	OTED	Description of NC Section A	Corrective Action Section B			Verif	ication	Approval	Approval
DATE	SIEP		Initial Chief Eng	Action Description Chief Eng	Sigr Dat	ı& _{Sec}	ction C	Chief Eng	QC Inspector
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CHEC	KED	APPROVED	DRAWING NO.	REV. A
DATE)C 40	TITLE	SHEET 1 OF 3 SCALE
REV	07.0	06.19 DATE	BRACKET ASSEMBLY DESCRIPTION	1:2
		07.06.10	NEWLOCKE	



D3531-041 BRACKET ASSEMBLY

NOTES:
1) FINISH: POWDER COAT ASSEMBLY BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3 **ALL PARTS**

2) ASSEMBLE PER DART QSI 003

3) IDENTIFY WITH DART P/N "D3531-041" USING WHITE MARKER ON INSIDE OF BRACKET ASSEMBLY, WHERE INDICATED

4) TRANSFER DRILL HOLES FROM D3531-1 BRACKET THROUGH D3531-3 BRACKET FRONT PLATE **BEFORE FINISHING**

PARTS LIST

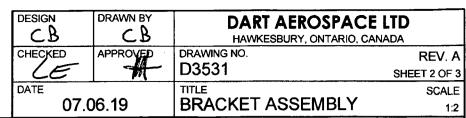
X D3531-041 BRACKET ASSEMBLY 1 D3531-1 BRACKET 1 D3531-3 BRACKET FRONT PLATE	QTY.	P/N	DESCRIPTION
	X	D3531-041	BRACKET ASSEMBLY
1 D3531-3 BRACKET FRONT PLATE	1	D3531-1	BRACKET
	1	D3531-3	BRACKET FRONT PLATE
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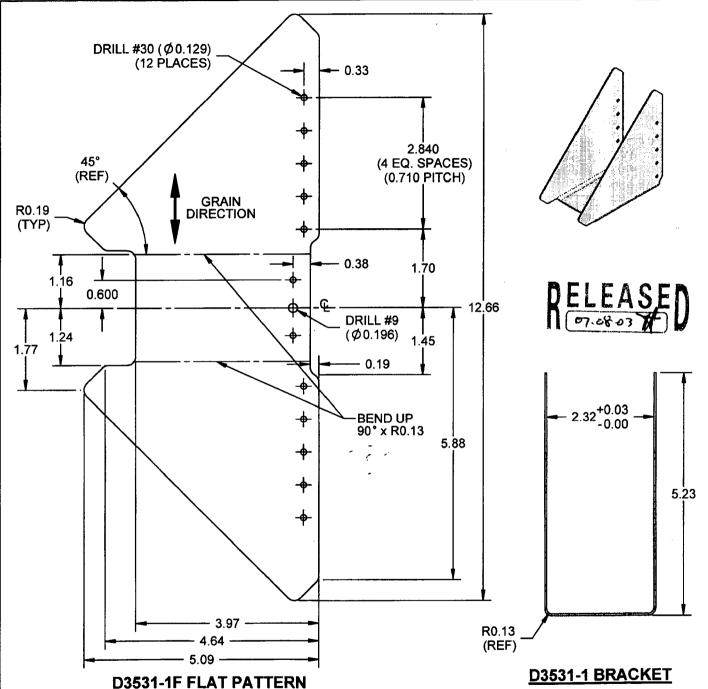
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DATE	STEP	Description of NC	Corrective Action Section B			Sign & Verifi			Approval	Approval
DAIL	SILF	Section A	Initial Chief Eng	Action Description Chief Eng	Sigi Da				Chief Eng	QC Inspector
								· · · · · · · · · · · · · · · · · · ·		







1) MATERIAL: ALUMINUM 6061-T6/T62 SHEET, 0.040 THICK PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF DART SPEC M6061T6S.040)
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX
- 6) PART IS SYMMETRIC ABOUT &

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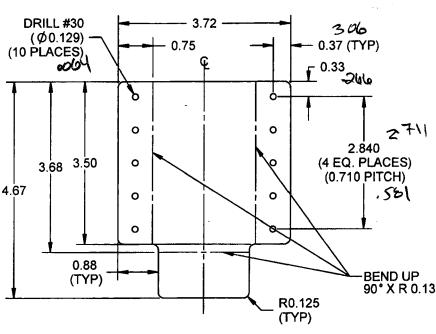
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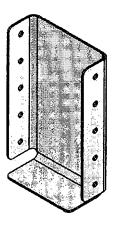
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W/O:			WO	RK ORDER CHANG	SES		··· •,·•······ • ···			
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NCR:			WORK ORDE	R NON-CONFORM	ANCE	(NCR)	l			
DATE	STEP	Description of NC	Corrective Action Section B			<u> </u>	Verific	cation	Approval	Approval
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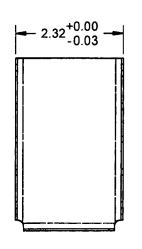
DESIGN	DRAWN BY	DART AEROSPACE HAWKESBURY, ONTARIO, CA	-
CHECKED	APPROVED	DRAWING NO.	REV. A SHEET 3 OF 3
DATE 07.0	06.19	BRACKET ASSEMBLY	SCALE 1:2

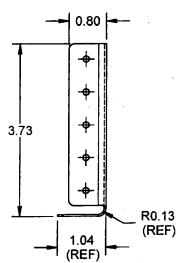






D3531-3F FLAT PATTERN





D3531-3 BRACKET FRONT PLATE

NOTES:
1) MATERIAL: ALUMINUM 6061-T6/T62 SHEET, 0.040 THICK PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF DART SPEC M6061T6S.040)
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX
- 6) PART IS SYMMETRIC ABOUT &

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w/061781

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W/O:			WORK ORDER CHAN						· · · · · · · · · · · · · · · · · · ·
DATE	STEP	PRO	PROCEDURE CHANGE			Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
									
Part No: PAR #:			Fault Categ	ory:	NCR: Yes	No DQ	A:	Date: _	•
Resolution:			Disposition: QA: N/C Closed: Date:						
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DATE	STEP	Description of NC	Corrective Action Section B				cation		Approval
	Section A	Section A	Initial Chief Eng	Action Description Chief Eng	Sign 8 Date		ion C	Chief Eng	QC Inspector
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